

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013028**Date Inspected:** 13-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Bay 1: CB15:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Bay 8:

This QA Inspector observed the following work in progress for CB17:

Repair welding of weld no: FB3057-053-043 of Corner Diaphragm Assembly for CB17. Welder is identified as 054459. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC Quality Control (QC) is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-3G(3F)-repair. Earlier, this weld was rejected on 04/08/10, by ZPMC UT technician, identified as Mr. Huang Jing.

Repair welding of weld no: FB3058-056-005 of Corner Diaphragm Assembly for CB17. Welder is identified as

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051324. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-repair. Earlier, this weld was rejected on 04/08/10, by ZPMC UT technician, identified as Mr. Huang Jing.

Outside Yard:

CB9:

This QA Inspector observed the following work in progress:

Repair welding of weld joint nos: CB202A-009-001, 002 & 003. Welder was identified as 066261. Welding process was identified as SMAW. ZPMC Quality Control (QC) is identified as Liu Chen Guang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-repair. This QA Inspector verified the CWR No: B-CWR1380 Rev-1 Dt: 04/12/10 & the UT report CB9-003R1 Dt: 04/09/10.

This QA Inspector observed the following work in progress:

Repair welding of weld joint nos: CB202A-009-016, 017 & 018. Welder was identified as 066261. Welding process was identified as SMAW. ZPMC Quality Control (QC) is identified as Liu Chen Guang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-repair. This QA Inspector verified the CWR No: B-CWR1362 Rev-1 Dt: 04/12/10 & the UT report CB9-001R1 Dt: 04/09/10.

CB10:

This QA Inspector observed the following work in progress:

ZPMC personnel identified as Mr. Chen Xi & ABF QA identified as Cao Hui Zhao, doing visual inspection after grinding of welds of this CB. This QA Inspector did random visual inspection of the welds and were found to be complying with the Contract documents. This QA Inspector also observed that the cope holes identified for grinding / rectification (during visual inspection earlier on 04/12/10) were corrected & were complying with the drawing requirements. Refer attached photos for reference.

CB11, CB12, CB13, CB14 & CB16:

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

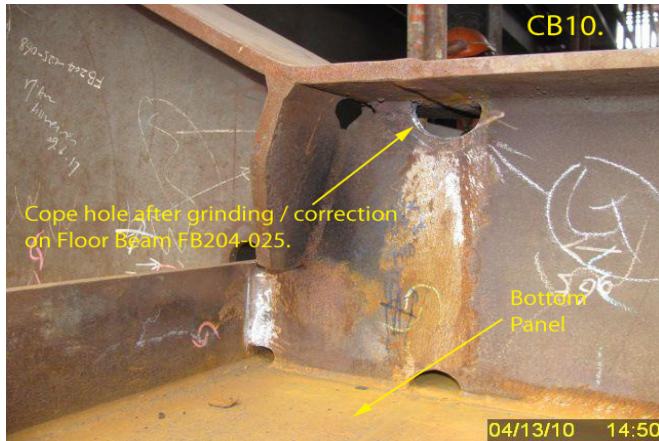
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Wadkar,Sailesh

Quality Assurance Inspector

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**Reviewed By:** Hall,Steven

QA Reviewer